

Work Order ID 83119

Friday, April 13, 2012 8:25:13 AM

83119

Page 1

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 Basket Base
 Start Date: 4/12/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/26/2012 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: *P* Date: 12-04-18 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100

0.00

100

Large Fab

Large Fab

Memo

0.00

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 - 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 - 3- tack weld mesh on basket as per dwg D2221
- A/R ER316 S.S. Rod Batch: M177130

PLEASE NOTE

IF MAKING -041A OR -043A :
 DRILL HOLES FOR GAS SPRING
 IN D3825-041 AS PER
 DSI 9473

Handwritten signature and date: 12-9-18

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

Handwritten stamp: DAS 24 12-9-18

Handwritten signature and date: 12-9-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00		DAS 16 2-3 01/09/12					
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00				1	716	129-19	

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes prior to 1ST COAT: <u>10-10</u> START TIME: <u>400</u> OVEN TEMPERATURE: <u>0 F</u> FINISH TIME: <u>40</u> *****2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<u>1X</u>	<u>0</u>		<u>M-L</u> <u>12/09/19</u>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>1</u>	<u>0</u>		<u>B</u> <u>129-19</u>

W122878

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Required Date: 4/26/2012 Req'd Qty: 1.00

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Reference:

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>D350-607-043</u>	0.00	<u>83116</u>			<u>1</u>	<u>0</u>	<u>12-9-19</u>	
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML5 12-09-19MLF
12-09-19

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Picklist Print

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Page 1

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	4.0000	1	1			
-------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**

CC 12-9-18

Location

Loc Qty

Loc Code

WA

4

B 86847 →

(A)

80163

4

✓ D2221-5 *D2221-5* Rib		Manufactured	No			100	Each	6.0000	2	2			
-------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**

CC 12-9-18

Location

Loc Qty

Loc Code

WA006

6

B 84793 →

(Z)

67117

2

78637

4

✓ D2221-7 *D2221-7* Rib		Manufactured	No			100	Each	0.0000	1	1			
-------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

**

B 88583 →

(IX)

CC 12-9-18

✓ D2232-3 *D2232-3* Basket Hinge		Manufactured	No			100	Each	19.0000	2	2			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

**

CC 12-9-18

Location

Loc Qty

Loc Code

WA

13

B 86914 →

(ZX)

82304

13

WA005

6

75581

2

78903

4

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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D2235-1

Manufactured No

100 Each 20.0000 2 2

**

CC 12-9-18

D2235-1

Basket Rib

Location

Loc Qty

Loc Code

WA

15

B86668 →

(2x)

78636

5

81910

10

WA005

5

66895

4

79153

1

D2581

Manufactured No

100 Each 32.0000 2 2

**

CC 12-9-18

D2581

Mounting Bracket

Location

Loc Qty

Loc Code

WA

26

B82877

82506

26

B86961 →

(2x)

WA005

6

69739

1

70766

2

77045

1

81253

2

D3442-1

Manufactured No

100 Each 23.0000 2 2

**

CC 12-9-18

D3442-1

Shim

Location

Loc Qty

Loc Code

WA

20

80788

20

WA005

3

71783

3

(2x)

Friday, April 13, 2012 8:25:18 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item: D2221

D2221

Parent Item Name: 350 Basket Base

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100 Each 2.0000 2 2

**

CC 12-9-18

D3825-041

Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

2

B87755 →

(2x)

78638

2

6.0000

2

2

**

CC 12-9-18

D3826-041

Manufactured No

100 Each 6.0000 2 2

D3826-041

Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

6

B89176 →

(2x)

81398

6

3.0000

1

1

**

CC 12-9-18

D3827-041

Manufactured No

100 Each 3.0000 1 1

D3827-041

Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA006

3

B87588 →

(1x)

72729

1

77546

2

0.0000

1

1

**

CC 12-9-18

D3832-1

Manufactured No

100 Each 0.0000 1 1

D3832-1

Mesh (Base)

D3833-1

Manufactured No

100 Each 7.0000 2 2

D3833-1

Mesh (Base End Face)

**

CC 12-9-18

Location

Loc Qty

Loc Code

WA

5

B-89208 →

(2x) (2x)

77521

5

WA035

2

79335

2

Shop Packet Print

Friday, April 13, 2012 8:25:18 AM

Page 3

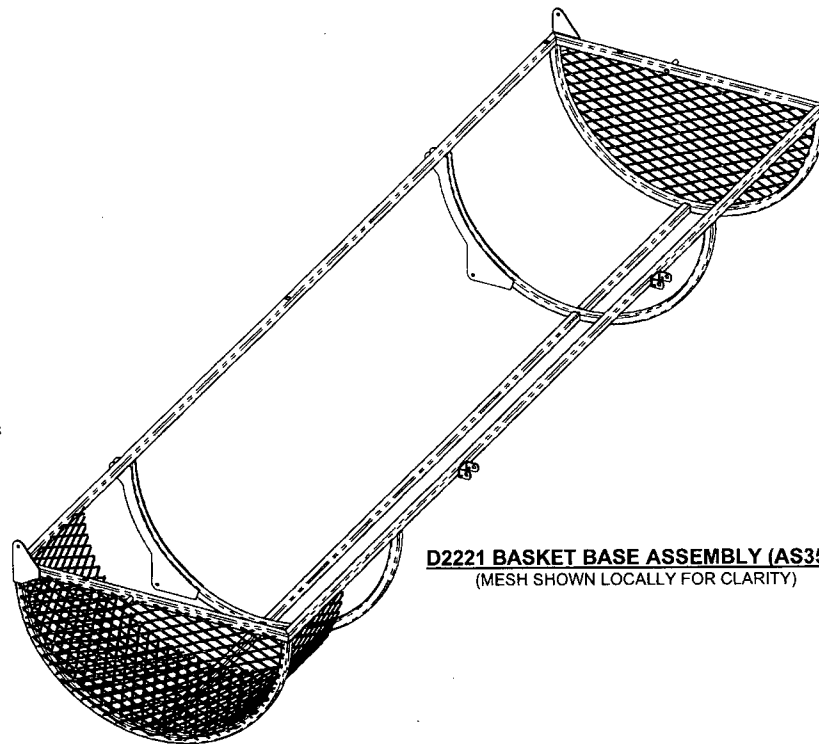
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83119

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A8-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.05.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD 14 WAKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

R12-04-12

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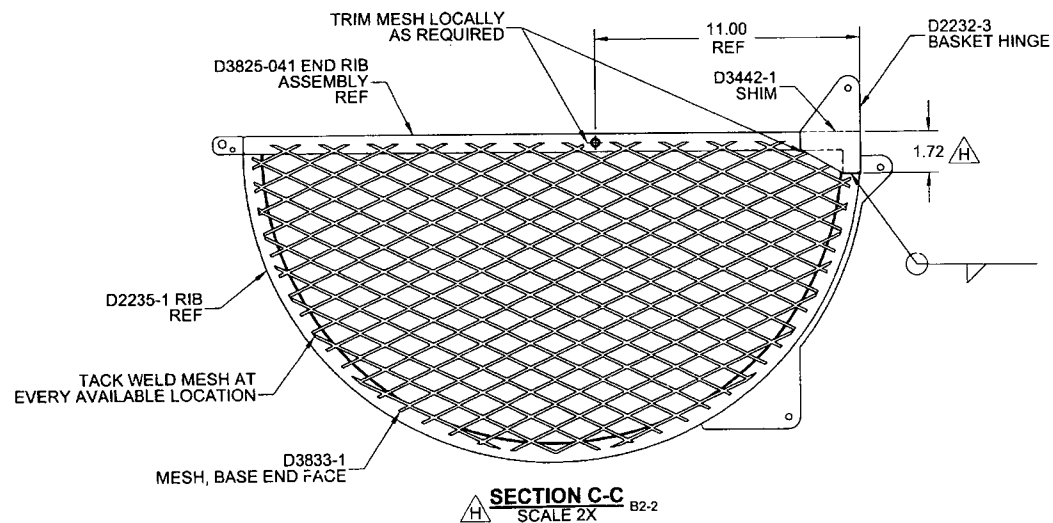
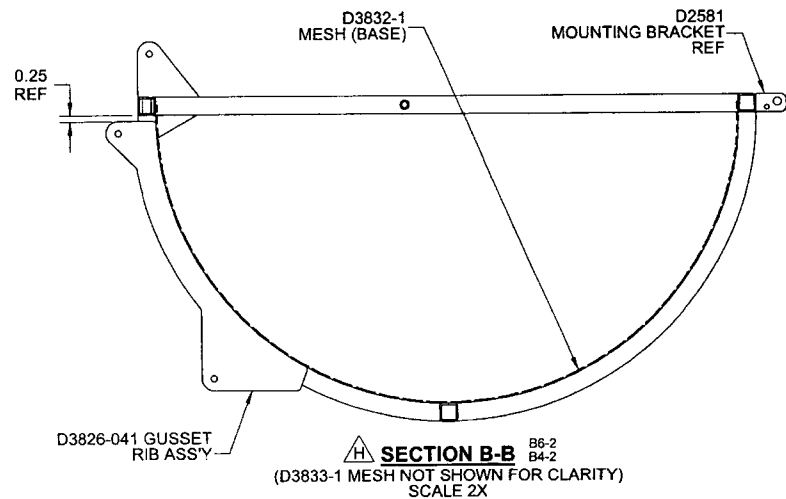
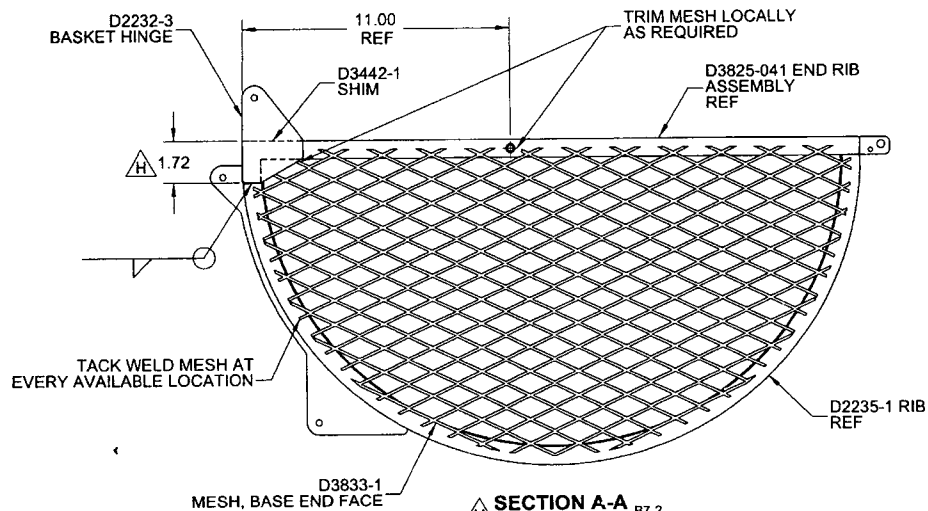
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83119

RELEASE
03/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>4-SS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>4-SS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>4-SS</i>	D2221	SHEET 3 OF 5
APPROVED	<i>4-SS</i>	TITLE	SCALE
DE APPR.	<i>4-SS</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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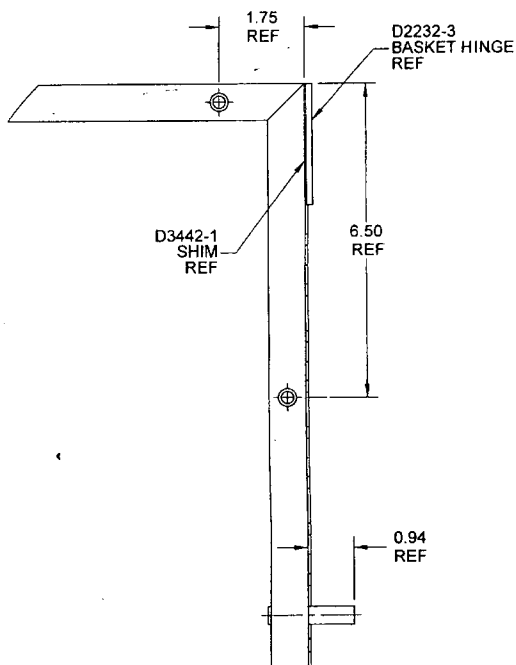
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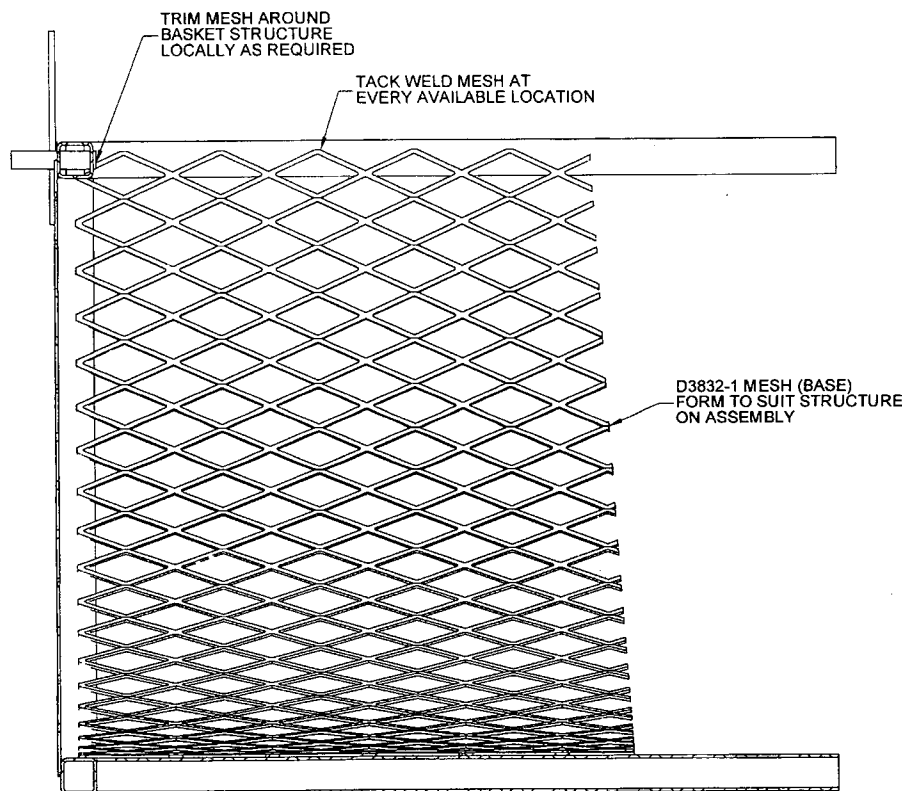
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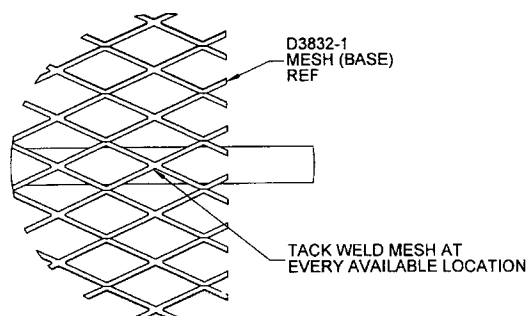
8 7 6 5 4 3 2 1



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



DETAIL E
SCALE 4X C6-2

RELEASED
02/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	11/8	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 4 OF 5
APPROVED	11/8	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

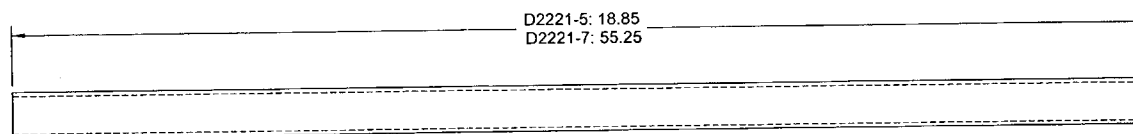
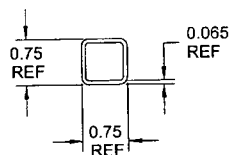
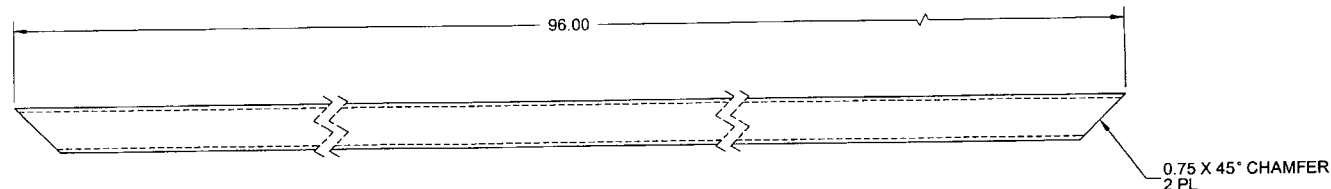
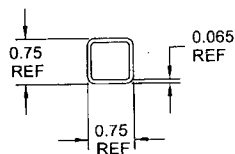
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>MS</i>	D2221	SHEET 5 OF 5
APPROVED	<i>W</i>	TITLE	SCALE
DE APPR.	<i>W</i>	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1984 BY DART AEROSPACE LTD	
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RELEASED
06/10/18 WJ

83119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries